

# Work Order ID 65426

January 17, 2011 1:36:31 PM



Page 1

Item ID:	D4035-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lid Rib Assembly, Fwd (350 Basket)					
Start Date:	1/17/11	Start Qty: 2.00		Cust Item ID:		
Required Date:	1/20/11	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>CL</u>	Date: <u>1/10/11</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4035	A

100	Weld per dwg A/R S.S. rod Batch: <u>111585</u>	0.00							
Large Fab	Memo	0.00							
Large Fab	1- Cut D4035-1 as per dwg D4035 2- Drill as per dwg D4035 using DT9562 3- remove identification marks and deburr 4- Weld bushing in rib as per dwg D4035								

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

④

SAM 10-01-26 Cpl 11-01-27

BE

11-01-28

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65426**

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Page 2

Item ID: D4035-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 1/17/11 Start Qty: 2.00



Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sulu131

(24)

130



Packaging

Packaging

Identify as per dwg &amp; Stock Location: WA

0.00

Memo

0.00

SAD  
11-02-01

(4)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/02/03  
MF  
11-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 65426

Parent Item: D4035-041

Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 1/17/11

Required Date: 1/20/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC  
IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3 Spacer Bushing		Manufactured	No			100	Each	21.0000	1				
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Location Loc Qty Loc Code

WA	21	
58974	1	
60320	1	
64048	1	
64920	18	

M304TS0.750W.049 304 SQ Tube .75x.75x.049W	Purchased	No			100	f	165.0299	1.75				
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Location Loc Qty Loc Code

MAT	120.5022679	
113763	0	
114323	8.15031894	
114677	0.00001	
114835	0.000039	
116319	32.7652	
116509	79.5867	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	44.5276	
114992	11.2825	
115260	33.2451	

2  
Cpl 11-01-27

4x

3.684211

SAD 11-01-26

7.3686

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

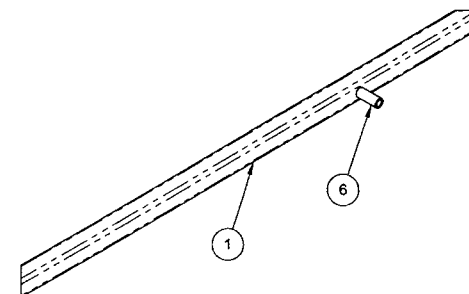
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

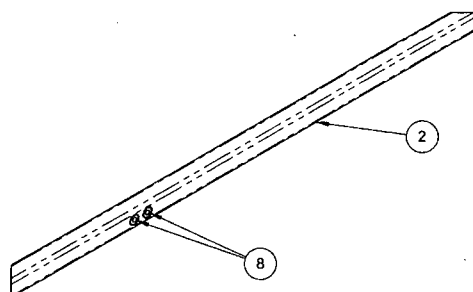
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

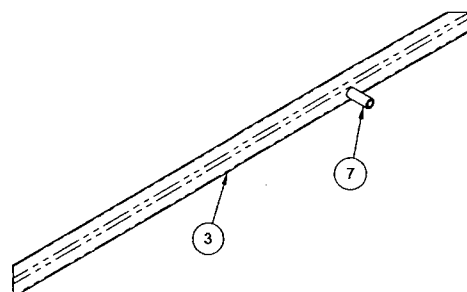
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



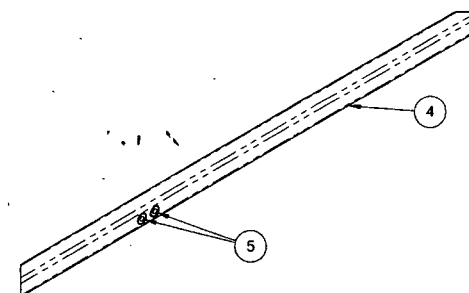
**D4035-041 BASKET LID RIB ASSY, FWD**



**D4035-043 BASKET LID RIB ASSY, AFT**



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

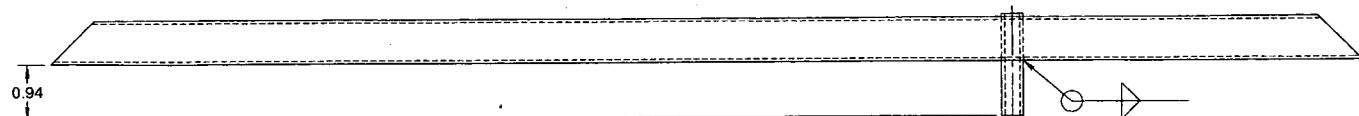
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2010-03-12

A	NEW ISSUE	DESCRIPTION	JPH	10.03.04
REV.			BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b>		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D4035	SHEET 1 OF 5	
APPROVED		TITLE	SCALE	
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8 7 6 5 4 3 2 1

D



D4035-1  
RIB

D2327-3  
SPACER BUSHING

**D4035-041 BASKET LID RIB ASSY. FWD**

C

B



D4035-3  
RIB

D4021-9  
BUSHING  
2 PL

TYP

**D4035-043 BASKET LID RIB ASSY. AFT**

A

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

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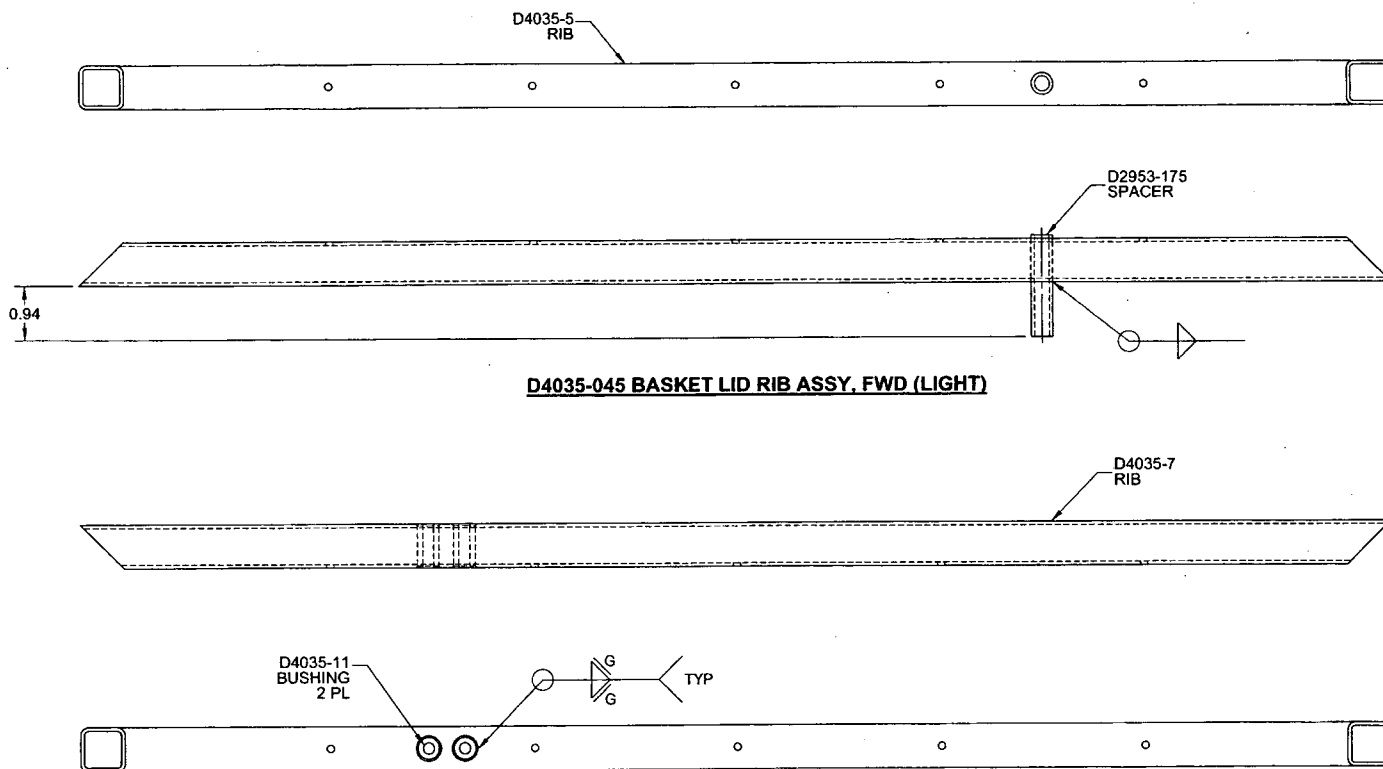
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MFG. APPR.		D4035	SHEET 2 OF 5
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8 7 6 5 4 3 2 1





**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**

**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

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NO. 65426

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

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8

7

6

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1

D

D

C

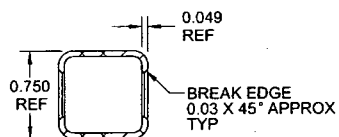
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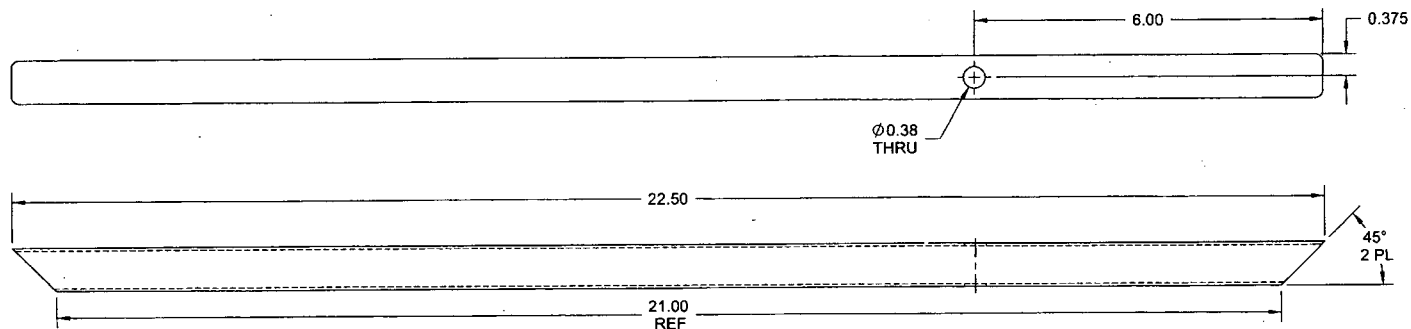
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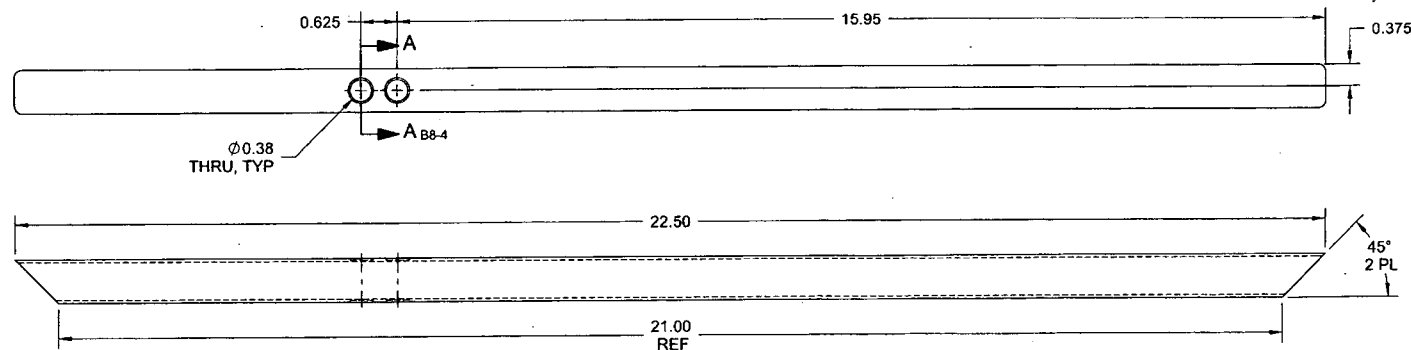
A



SECTION A-A 85-4



D4035-1 RIB



D4035-3 RIB

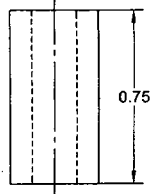
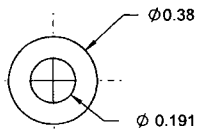
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## NOTES:

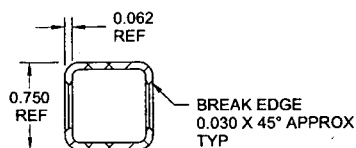
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
PER ASTM A554/A269 MILL FINISH  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.80 lbs

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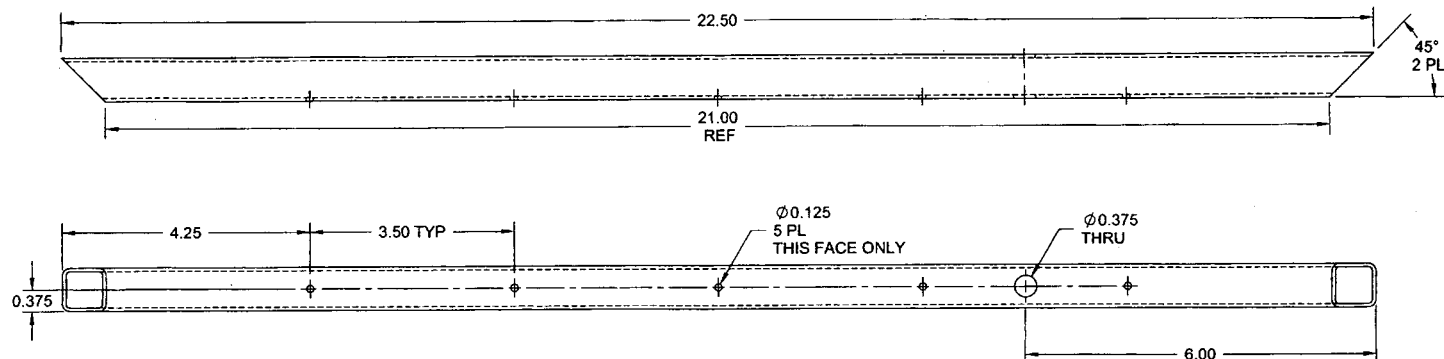
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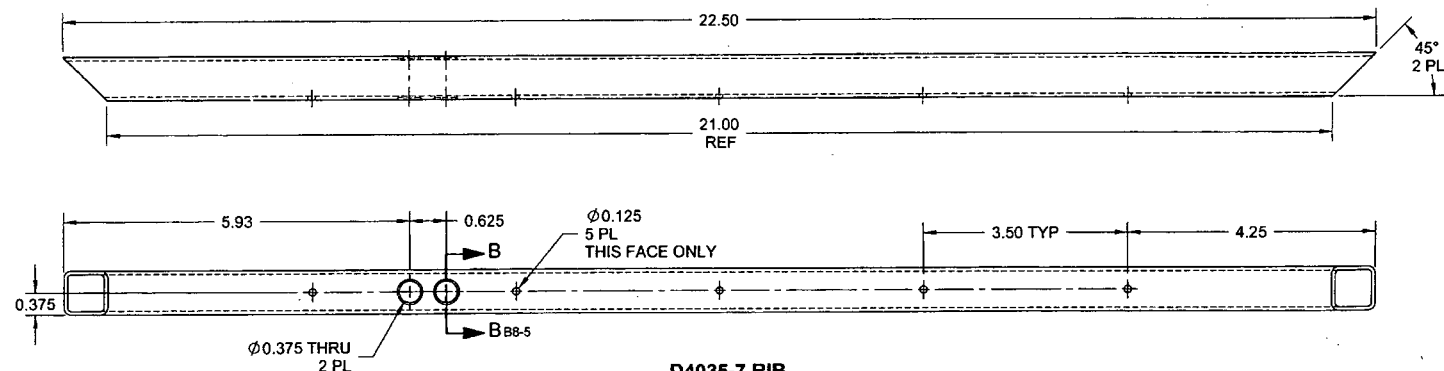
**D4035-11 BUSHING**



**SECTION B-B** 95-5



**D4035-5 RIB**



**D4035-7 RIB**

**NOTES:**

- 1) MATERIAL: -5 & -7: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6TS0.750W.062  
-11: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -5 & -7: 0.33 lbs; -11: 0.01 lbs

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DRAWN	JFH	DRAWING NO. <b>D4035</b>	REV. A
CHECKED			SHEET 5 OF 5
MFG. APPR.		TITLE <b>BASKET LID RIB ASSY</b>	SCALE NTS
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DE APPR.		DATE <b>10.03.04</b>	

